



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4278-047
Job Sheet 190982



Part No: D4278-047

Job Qty: 2 pcs

Part Name: Upper Rib Assembly-Straight



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 3/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4278 REV C SHEET 4, D4277 REV D SHEETS 1,2 IPP Rev:A 10.11.12 new issue DD verf:EC IPP
Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	2 pcs	3/1/19		0.00	2.60	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		DAS
							Large Fab - 3		24
							Large Fab - 4		9-89
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		MA
110	QC 10	2 pcs	3/1/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		Q
							QC 10 - 9		
120	QC 5	2 pcs	3/1/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

Plex 2/20/19 12:51 PM Dart.lajeunesse.marie

				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	Q
				QC 5 - 30	
130 Packaging 3-1 - Stock - B4B 2 pcs	3/1/19	0.00 0.00	Packaging 3 - 1 - B4B		
			Packaging 3 - 2 - B4B		
			Packaging 3 - 3 - B4B		
			Packaging 3 - 4 - B4B		
			Packaging 3 - 5 - B4B		
			Packaging 3 - 6 - B4B		
			Packaging 3 - 7 - B4B		
			Packaging 3 - 8 - B4B		
			Packaging 3 - 9 - B4B		
			Packaging 3 - 10 - B4B		
			Packaging 3 - 11 - B4B		MA
			Packaging 3 - 12 - B4B		
			Packaging 3 - 13 - B4B		
			Packaging 3 - 14 - B4B		
			Packaging 3 - 15 - B4B		
			Packaging 3 - 16 - B4B		
			Packaging 3 - 17 - B4B		
			Packaging 3 - 18 - B4B		
			Packaging 3 - 19 - B4B		
			Packaging 3 - 20 - B4B		
			Packaging 3 - 21 - B4B		
			Packaging 3 - 22 - B4B		
			Packaging 3 - 23 - B4B		
			Packaging 3 - 24 - B4B		
			Packaging 3 - 25 - B4B		
			Packaging 3 - 26 - B4B		
			Packaging 3 - 27 - B4B		
			Packaging 3 - 28 - B4B		
			Packaging 3 - 29 - B4B		
			Packaging 3 - 30 - B4B		
			Packaging 3 - 31 - B4B		
			Packaging 3 - 32 - B4B		
			Packaging 3 - 33 - B4B		
			Packaging 3 - 34 - B4B		
			Packaging 3 - 35 - B4B		
140 QC 21 - SA 2 pcs	3/1/19	0.00 0.00	QC 21 - SA - 21		MAR 22 2019 DAG 21
			QC 21 - SA - 70		
			QC 21 - SA - 53		

Part Op 100 - Weld per dwg A/R S.S. rod Batch: 138840 1- Cut D4277-1 tube as per dwg D4277 2- Drill and chamfer holes
 Descriptions: on both side using DT9715 3- Remove marking 4-Debur 5- Assemble bushing and weld as per dwg 6- Grind weld flush
 as per dwg

110 - QC10- Inspect visual per QSI004- ground welds

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: ***STOCK IN BASKET CELL ***

140 - QC21- Final Inspection - Work Order Release

Master Unit # 008739

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-9	Bushing	8 pcs (4 ea)	100-Large Fab - Basket - 1	5115 312
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	4.1600 ft (2.08 ea)	100-Large Fab - Basket - 1	5149 963

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D4021-9	8	203	0
	M304TS0.750W.049	4	368	0

Part Specifications

Specifications could not be found.

Plex 2/20/19 12:51 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

D4035-047

D4306-044 -043



Container No: S165039



Part: D4278-047

Job No: 190982

Serial No/Batch: S165039

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/21/19